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RB KIT 407M-31
Job Sheet 200564



Part No: RB KIT 407M-31

Job Qty: 12 pcs

Part Name: Gauge Pin .1920" dia.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 10/7/19

Created By: Chantal Lavoie

Type: SOLD

Description:

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.29 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
90	Purchasing	12 pcs		10/7/19	0.00	0.00	Purchasing - 1	
							Purchasing - 2	
							Purchasing - 3	
95	Packaging 2-1 - Receive - B4B	12 pcs		10/7/19	0.00	0.00	Packaging 2 - 1 - B4B	
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	

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100 QC 6	12 pcs	10/7/19	0.00 0.00	Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
110 Small Fab - 2 - B4B	12 pcs	10/7/19	0.00 1.50	QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
				Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
120 QC 5	12 pcs	10/7/19	0.00 0.00	Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	GP 19-11-18
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
130 Packaging 3-1 - Stock - B4B	12 pcs	10/7/19	0.00 0.00	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
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				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
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				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

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				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
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				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - SA	12 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

QAS
21
2-22

GA
090

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Part Op 90 - (Purchasing)

Descriptions: 95 - (Receive & Inspect for Damage & Mat'l Certs)

100 - (QC6- All purchased or subcontracted products)

110 - 1-Cut pin in half, 2-Debur 3-Put pin in small sealable plastic bag with a small amount of LPS 2 to prevent corrosion.

4-Package as per note 10.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
21135A55	Plug Gauge .1920"	6 Ea (.5 ea)	90-Purchasing	220912

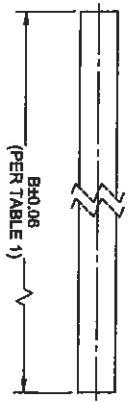
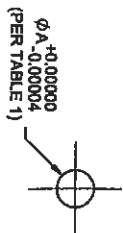
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Purchasing	21135A55	6	5	0

Part Specifications

Specifications could not be found.

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 20030

TABLE 1
GAUGE PIN DIMENSIONS

PART NUMBER	\phi A	B	PURCHASE PART NUMBER (MASTER COPY)
RB KIT 407M-01	\phi.02400	1.00"	21135A52 OR EQUIV.
RB KIT 407M-03	\phi.04000	1.00"	21135A53 OR EQUIV.
RB KIT 407M-05	\phi.05400	1.00"	21135A53 OR EQUIV.
RB KIT 407M-07	\phi.06000	1.00"	21135A53 OR EQUIV.
RB KIT 407M-09	\phi.08000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-11	\phi.08800	1.00"	21135A54 OR EQUIV.
RB KIT 407M-13	\phi.10800	1.00"	21135A54 OR EQUIV.
RB KIT 407M-15	\phi.12000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-17	\phi.14400	1.00"	21135A54 OR EQUIV.
RB KIT 407M-19	\phi.14400	0.25"	21135A54 OR EQUIV.
RB KIT 407M-21	\phi.16000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-23	\phi.16000	0.25"	21135A54 OR EQUIV.
RB KIT 407M-25	\phi.17280	1.00"	21135A54 OR EQUIV.
RB KIT 407M-27	\phi.17280	0.25"	21135A54 OR EQUIV.
RB KIT 407M-29	\phi.18000	1.00"	21135A54 OR EQUIV.
RB KIT 407M-31	\phi.18200	1.00"	21135A55 OR EQUIV.

RB KIT 407M-01 THRU -31 \phi.XXXX, CLASS X PLUG NO-GO GAUGE

- NOTES:
- 1) MATERIAL: SEE TABLE 1 FOR MATERIAL SPECIFICATION
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = $\pm 0.1^\circ$ / $\pm 1^\circ$
X.XX = $\pm 0.01^\circ$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005^\circ$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005^\circ$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005^\circ$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A

DESIGN	DRAWN	CHECKED	DATE	1/17/2019
MBB	KPT	DP		
TITLE				
RB KIT 407M				
SPLINE MEASURING KIT				
REV. D				
SHEET 3 OF 6				
SCALE				
NTS				

DATE 1/17/2019

DESIGNER: 2019 BY DART AEROSPACE LTD

REVISION: 1.0

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